

Work Order ID 95813***95813***

Page 1

January-18-13 11:24:18 AM

Item ID: D3016-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Seat Frame Assembly

Stop

NS2

Start Date: 1/28/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/28/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

*PL*Date: 130121 Tooling:

Date:

Run

Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|------------------------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3016 | RevA / DEO A-1 | | | | | | | | |
| 100 *100* Large Fab | Weld per dwg A/R 4130 rod Batch: <u>A-118875</u> 0.00 Large Fab | | | | | | | | <u>1-62 13-8-15</u> |
| | Memo 1-Cut all tubes as per Dwg D3016 | 0.00 | | | | | | | |
| | 2-Deburr | | | | | | | | |
| | 3-Assemble tubes, fittings and weld as per Dwg D3016 using welding jig DT8597 | | | | | | | | |
| | 4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041 | | | | | | | | |
| | 5- Assemble brackets and gusset per dwg and weld | | | | | | | | |
| 110 *110* QC Quality Control | QC9- Inspect visual per QSI004- Fusion Welds | 0.00 | | | | | | | <u>① 13-08-15 DAS 09</u> |
| | Memo | 0.00 | | | | | | | |

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | | | | | |
|--|------|------|--|---|------------------------------------|--|--------------------------------------|---|-------------|--------------|--------------|--|--|---|--|
| Part No. _____ | | | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | |
| NCR No. _____ | | | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | |
| | | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | |
| | | | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector | | | | |
| Doc/Data | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | |
| | | | | | | | | | | | | | | <input type="checkbox"/> Other | |
| | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | |
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| | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | |

Work Order ID 95813

January-18-13 11:24:18 AM

Item ID: D3016-041

Revision ID:

Item Name: Seat Frame Assembly

Start Date: 1/28/13 Start Qty: 1.00 *1*

Required Date: 1/28/13 Req'd Qty: 1.00 *1*

Reference:

Approvals: Process Plan: _____

Date: _____ Tooling: _____

Cust Item ID:

QC: _____

Date: _____ SPC (Y/N): _____

Customer:

Setup Start *NS1*

Stop *NS2*

Sequence ID/
Work Center ID
120

120

QC

Quality Control

Operation
Description
QC5- Inspect part completeness to step on W/OSet Up/
Run Hours
0.00

Run Start *NR1*

Stop *NR2*

130
130
Powdercoat
Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

0. 130815

DAS
09

140

140

QC

Quality Control

QC3- Inspect Part Finish

0.00

1x8 M/ 13/08/16

1x d M/ 13/08/16

W121279

8-15
Install paint screws on fitting ends
START TIME: 8-15
OVEN TEMPERATURE: 320°F
FINISH TIME: 8-45

0.00

NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| | | | | | | | | | | | |
|--|--|------|------|---|--|--|--|--|-------------|--------------|--------------|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
| | | | | Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | |
| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube | | | | | General Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other <input type="checkbox"/> | | | | | | |

Work Order ID 95813

January-18-13 11:24:18 AM

Item ID: D3016-041

Accept

95813

Page 3

Revision ID:

Item Name: Seat Frame Assembly

Start Date: 1/28/13 Start Qty: 1.00

1

Required Date: 1/28/13 Req'd Qty: 1.00

1

Reference:

Approvals: Process Plan:

Date: _____ Tooling: _____

Cust Item ID:

Setup Start ***NS1***

QC: _____

Date: _____ SPC (Y/N): _____

Customer:

Stop ***NS2***Sequence ID/
Work Center IDOperation
Description

150

Identify as per dwg & Stock Location: 6A***150***

Packaging

Packaging

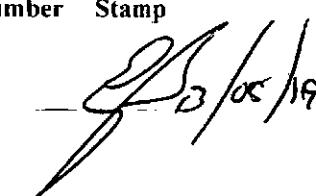
Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

/X



160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Quality Control

Memo

0.00

MLJ 13-0821MLJ 13-05-20

NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | | | | |
|---|--|------|------|--|--|--|--|---|--|-------------|--------------|--|--|---|--|
| | | | | Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | | | | | |
| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector | | | |
| Doc/Data | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | |
| Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube | | | | General Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> | | | | Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> | | | | Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> | | Pressure/Forced Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> | |
| | | | | | | | | | | | | <input type="checkbox"/> | | | |

Picklist Print

January-18-13 11:24:18 AM

Page 1

Work Order ID: 95813

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 1/28/13

Required Date: 1/28/13

Comments: IPP A01.09.19 New issue CIPP RevB: as per revB DD verified by JLM

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M4130NT0.750W.049 4130 RD Tube .750 x.049W | | Purchased | No | | | 100 | f | 145.0218 | 4.3 | 4.5263158 | | EL 13-8-12 | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | | | | | |
| | | | | MAT033 | | | 145.0217893 | | | | | | |
| | | | | | 123339 | | 27.5217893 | | | | | | |
| | | | | | 124293 | | 117.5 | | | | | | |
| | | | | | | | | | | | | | |
| M4130NT0.500W.049 4130 RD Tube .500 x.049W | | Purchased | No | | | 100 | f | 94.6960 | 4.3 | 4.5263158 | | EL 13-8-12 | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | | | | | |
| | | | | MAT032 | | | 94.696 | | | | | | |
| | | | | | 121025 | | .82 | | | | | | |
| | | | | | 123339 | | 41.876 | | | | | | |
| | | | | | 124293 | | 51 | | | | | | |
| | | | | | | | | | | | | | |
| M4130NT1.000W.120 4130 RD Tube 1.00 x .120wall | | Purchased | No | | | 100 | f | 24.5000 | 1.5 | 1.5789474 | | EL 13-8-12 | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | | | | | |
| | | | | MAT033 | | | 24.5 | | | | | | |
| | | | | | 124293 | | 24.5 | | | | | | |
| D3016-17 Gusset | | Manufactured | No | | | 100 | Each | 16.0000 | 2 | 2 | | EL 13-8-15 | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | | | | | |
| | | | | WA002 | | | 16 | | | | | | |
| | | | | | 70909 | | 4 | | | | | | |
| | | | | | 92391 | | 12 | | | | | | |
| D3016-13 Bracket | | Manufactured | No | | | 100 | Each | 13.0000 | 2 | 2 | | EL 2 13-8-15 | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | | | | | |
| | | | | WA002 | | | 13 | | | | | | |
| | | | | | 90292 | | 6 | | | | | | |
| | | | | | 92380 | | 7 | | | | | | |

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
|---|--|--|---|---|------------------------------------|--------------------------------------|--------------------|-------------|--------------|--------------|
| Part No. _____ | Rework <input type="checkbox"/> | Scrap <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | |
| NCR No. _____ | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | |
| | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | |
| Operator | | | | | | | | | | |
| Material | | | | | | | | | | |
| Setup | | | | | | | | | | |
| Other | | | | | | | | | | |
| Process | | | | | | | | | | |
| Supplier | | | | | | | | | | |
| Training | | | | | | | | | | |
| Unapproved | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | |
| Landing Gear | | | General | | | | | | | |
| Bending <input type="checkbox"/> | Bend <input type="checkbox"/> | Grain <input type="checkbox"/> | Ovalized <input type="checkbox"/> | | | | | | | |
| Centre Not Concentric to O/S <input type="checkbox"/> | BOM/Route <input type="checkbox"/> | Hardware <input type="checkbox"/> | Pressure/Forced <input type="checkbox"/> | | | | | | | |
| Cracks <input type="checkbox"/> | Broken/Damaged <input type="checkbox"/> | Inspection Incomplete <input type="checkbox"/> | Over/Under tolerance <input type="checkbox"/> | | | | | | | |
| Crushed/Crimped. <input type="checkbox"/> | Burrs <input type="checkbox"/> | Instructions Incomplete/Unclear <input type="checkbox"/> | Part Incorrect <input type="checkbox"/> | | | | | | | |
| Cuffs <input type="checkbox"/> | Contamination <input type="checkbox"/> | Maintenance <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/> | | | | | | | |
| Heat Treat <input type="checkbox"/> | Countersink <input type="checkbox"/> | Mislabeled <input type="checkbox"/> | Part Moved <input type="checkbox"/> | | | | | | | |
| Inspection Strip in Tube <input type="checkbox"/> | Cut Too Short <input type="checkbox"/> | Offset <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/> | | | | | | | |
| Ripples in Bend <input type="checkbox"/> | Drill Holes <input type="checkbox"/> | Out of Calibration <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/> | | | | | | | |
| Torque Waves in Extrusion <input type="checkbox"/> | Drawing <input type="checkbox"/> | Out of Sequence <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | |
| Turning Sequence <input type="checkbox"/> | Finish <input type="checkbox"/> | Outside Dimensions <input type="checkbox"/> | | | | | | | | |
| Wave/Twist in Tube <input type="checkbox"/> | Folio <input type="checkbox"/> | | | | | | | | | |

Picklist Print

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Page 2

Work Order ID: 95813

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 1/28/13

Required Date: 1/28/13

Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | | |
|----------|--------------|----|-----|------|--------|---|----------|----------------|
| D3016-15 | Manufactured | No | 100 | Each | 5.0000 | 2 | <u>2</u> | <u>13-8-75</u> |
| Gusset | | | | | | | | |

| | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|---------|-----------------|----------------|-----------------|
| 9569512 | WA002 | 5 | |
| | 90616 | 5 | |

| | | | | | | | | |
|---------|--------------|----|-----|------|---------|---|----------|----------------|
| D3020-1 | Manufactured | No | 100 | Each | 24.0000 | 4 | <u>4</u> | <u>13-8-12</u> |
| Fitting | | | | | | | | |

| | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|--|-----------------|----------------|-----------------|
| | WA | 13 | |
| | 86801 | 13 | |
| | WA001 | 11 | |
| | 94656 | 11 | |

97712 x 4

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

| Work Order: _____ | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
|--|------|------|--|---|------------------------------------|--|--------------------------------------|---|-------------|--------------|--------------|
| | | | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | |
| | | | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | |
| | | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | |
| | | | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | |
| | | | | | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | | |
| | | | | | | | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | | | |
| | | | | | | | | <input type="checkbox"/> Other | | | |

DART

| | | | |
|---------------------|-----------------------|---|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>#</i> | APPROVED <i>#</i> | DRAWING NO. D3016 | REV. A SHEET 1 OF 3 |
| DATE 01.05.18 | | TITLE SEAT FRAME ASSEMBLY | SCALE NTS |
| A | 01.05.18 | NEW ISSUE | |

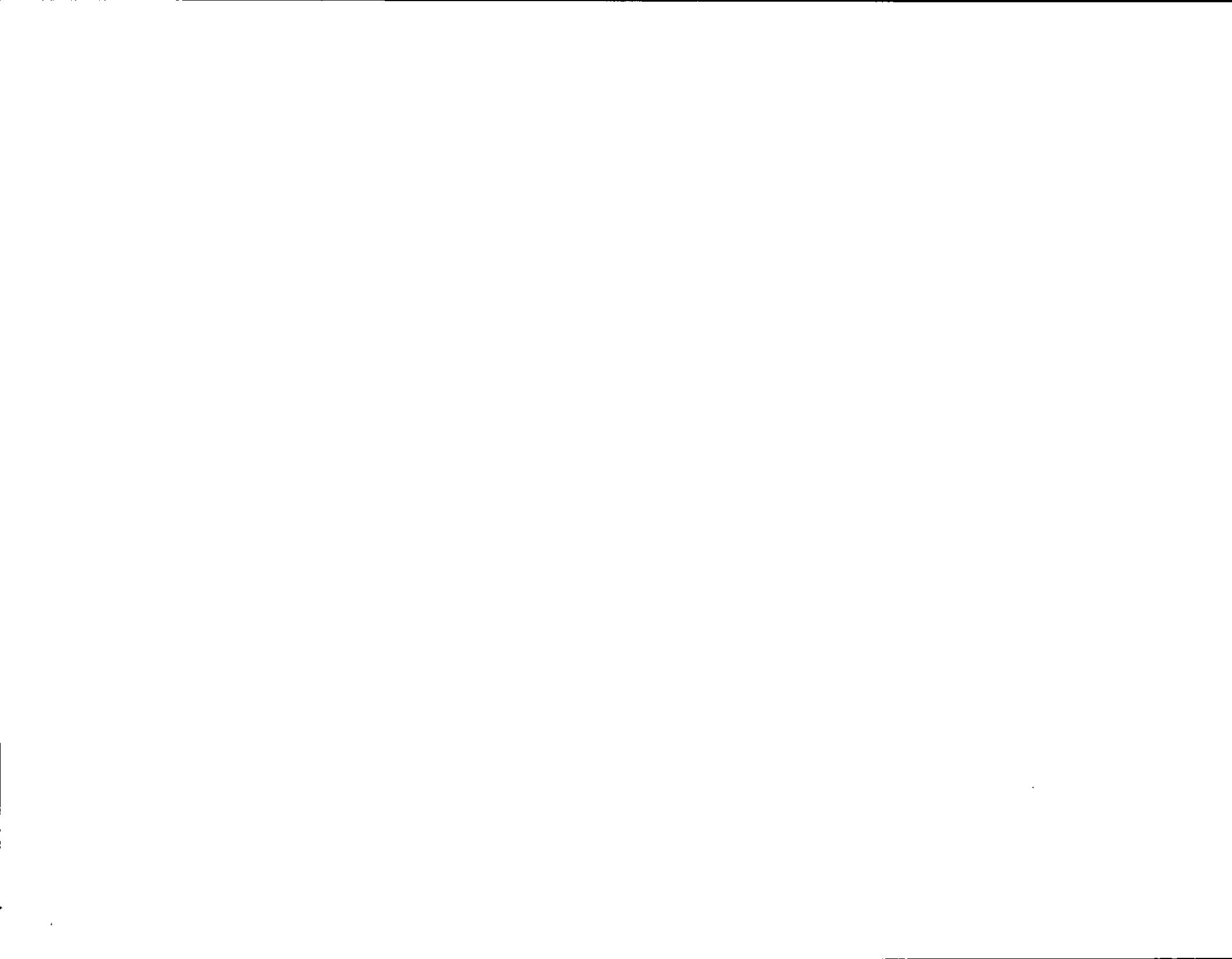
| QTY | PART NUMBER | DESCRIPTION | MATERIAL |
|-----|-------------|---------------------|--|
| X | D3016-041 | SEAT FRAME ASSEMBLY | N/A |
| 1 | D3016-1 | TUBE | AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049) |
| 2 | D3016-3 | TUBE | AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049) |
| 1 | D3016-5 | TUBE | AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049) |
| 2 | D3016-7 | TUBE | AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049) |
| 1 | D3016-9 | SADDLE | AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120) |
| 1 | D3016-11 | SADDLE | AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120) |
| 1 | D3016-13 | BRACKET | AISI 4130N SHEET, 18 GAUGE (M4130N-S049) |
| 1 | D3016-15 | GUSSET | AISI 4130N SHEET, 18 GAUGE (M4130N-S049) |
| 1 | D3016-17 | GUSSET | AISI 4130N SHEET, 18 GAUGE (M4130N-S049) |
| 2 | D3020-1 | FITTING | N/A |

NOTES

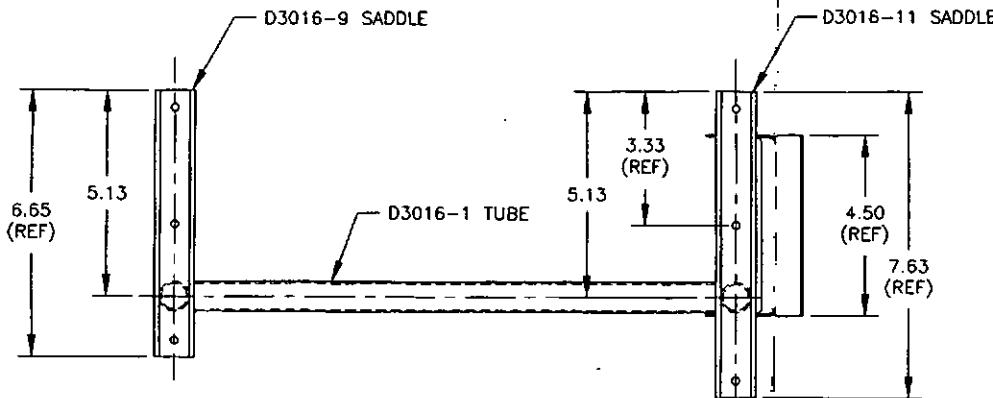
- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

*95813
01/3-01-22***DEO ATTACHED****RELEASED**
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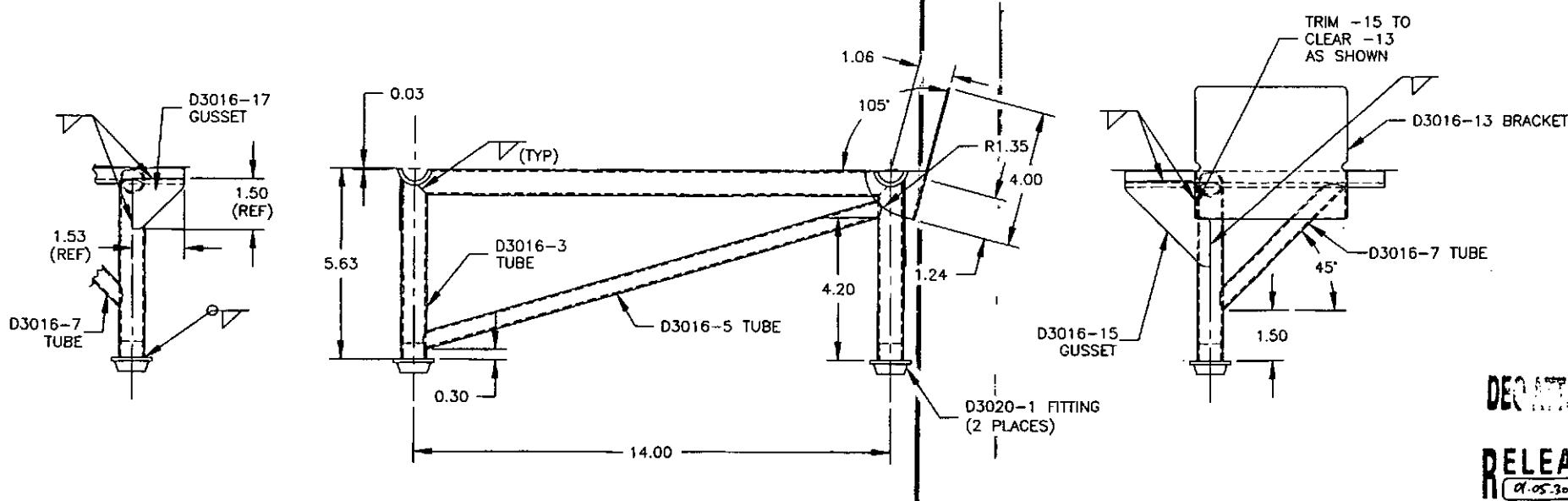
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D3016-041 SEAT FRAME ASSEMBLY



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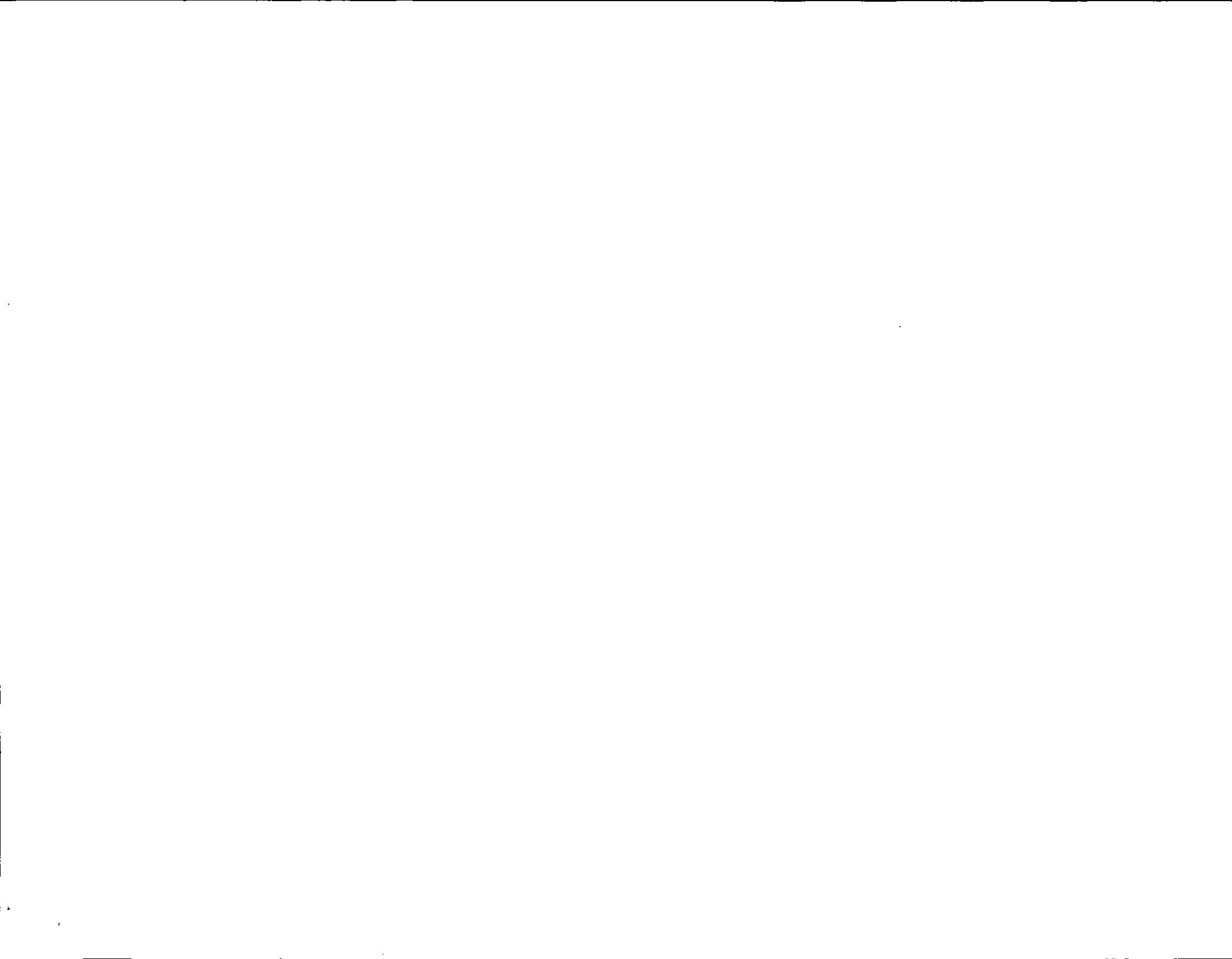


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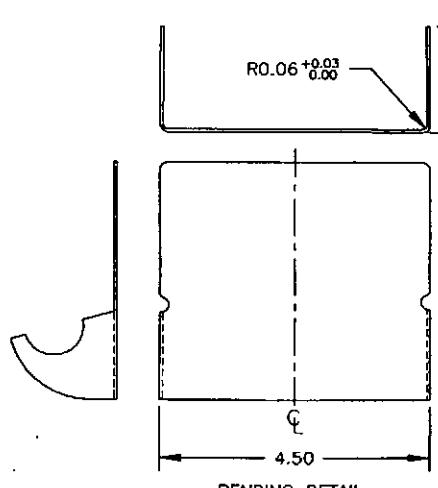
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01-05-30

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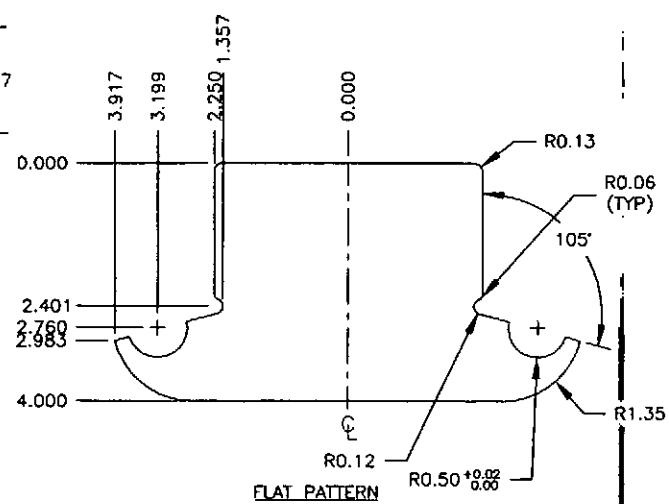
| DESIGN | DRAWN BY | DART | DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA |
|------------------|----------|------------------------------|---|
| UP | UP | | REV. A |
| CHECKED | APPROVED | DRAWING NO. D3016 | SHEET 2 OF 3 |
| DATE 01.05.18 | | TITLE SEAT FRAME ASSEMBLY | SCALE 1:3 |



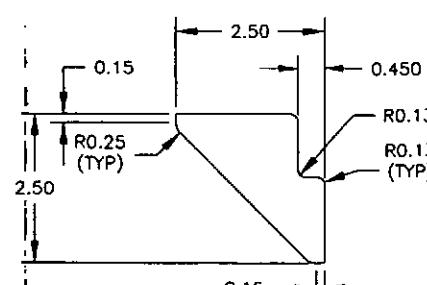
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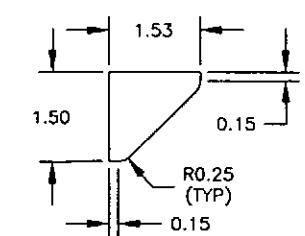
BENDING DETAIL



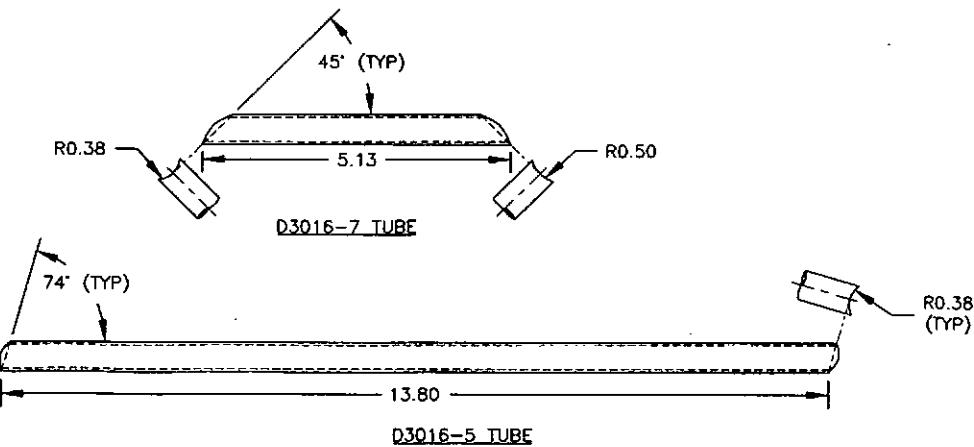
D3016-13 BRACKET



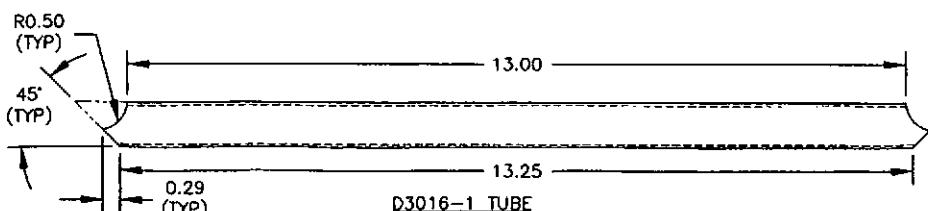
D3016-15 GUSSET



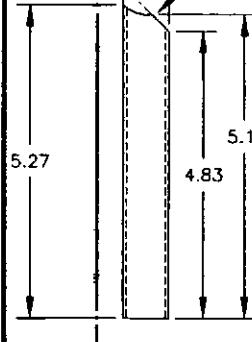
D3016-17 GUSSET



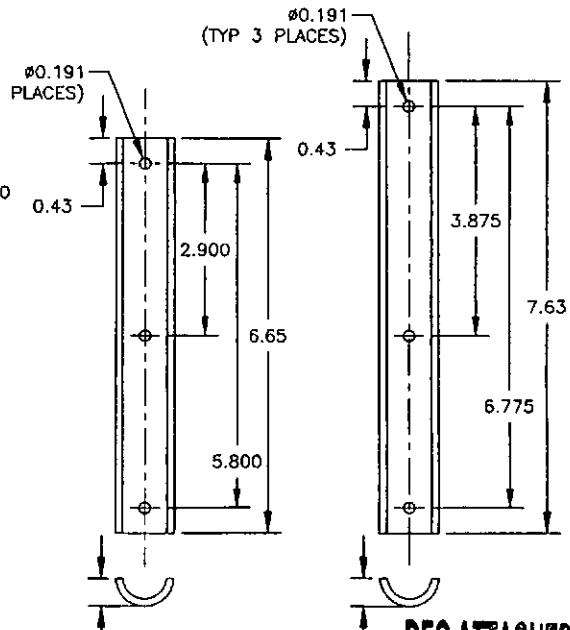
D3016-5 TUBE



D3016-1 TUBE



D3016-3 TUBE



D3016-9 SADDLE

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HAWTHORPE, ONTARIO, CANADA

REV. A

SHEET 3 OF 3

1:2

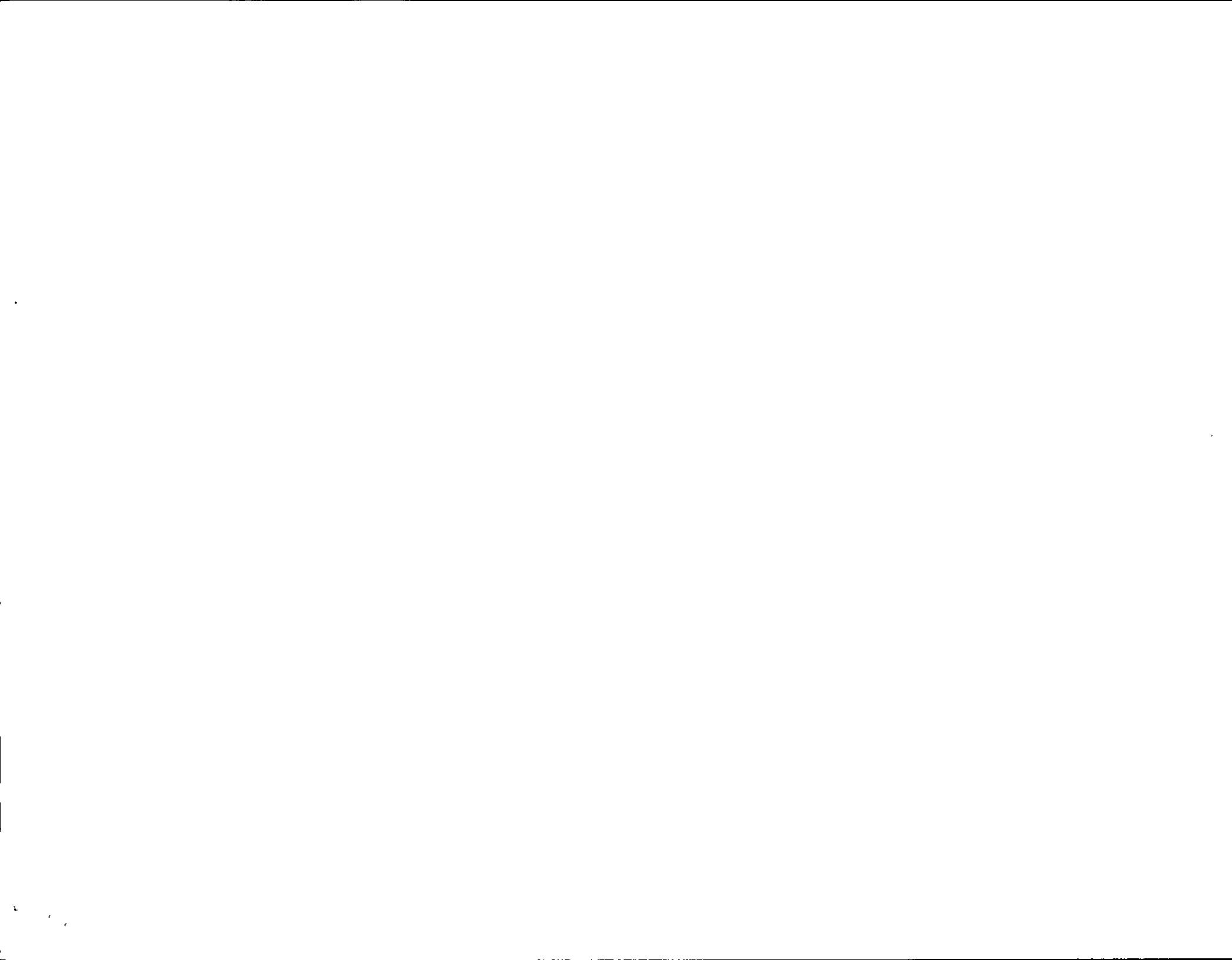
SCALE

TITLE

SEAT FRAME ASSEMBLY

DATE

01.05.18



| | | | | | | |
|----------------------|------------------------------|-------------------------|---|-------------------------|---------------------------|--------------|
| DRAWING NO. D3016 | TITLE SEAT FRAME ASSEMBLY | REV. A | DART AEROSPACE LTD ENGINEERING ORDER | D.E.O. NO. D3016-A-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN 1 | CHECKED <i>JP</i> | MFG. APPR. <i>RE</i> | APPROVED <i>MP</i> | DE APPR. <i>MP</i> | | |
| DATE 10.01.29 | DATE 10.01.29 | DATE 10.01.29 | DATE 10.01.29 | DATE 10.01.29 | DATE 10.01.29 | |

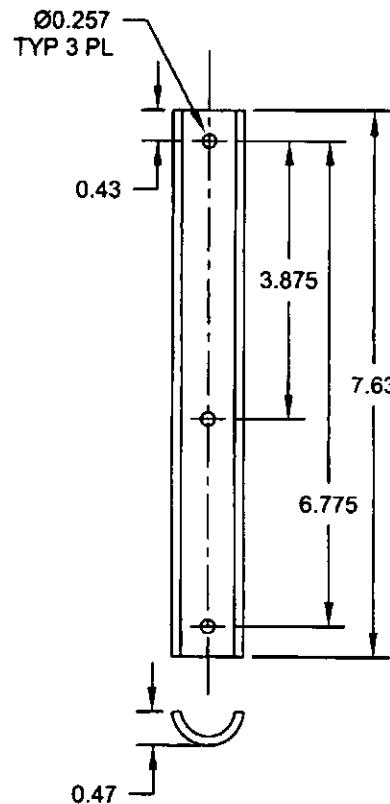
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

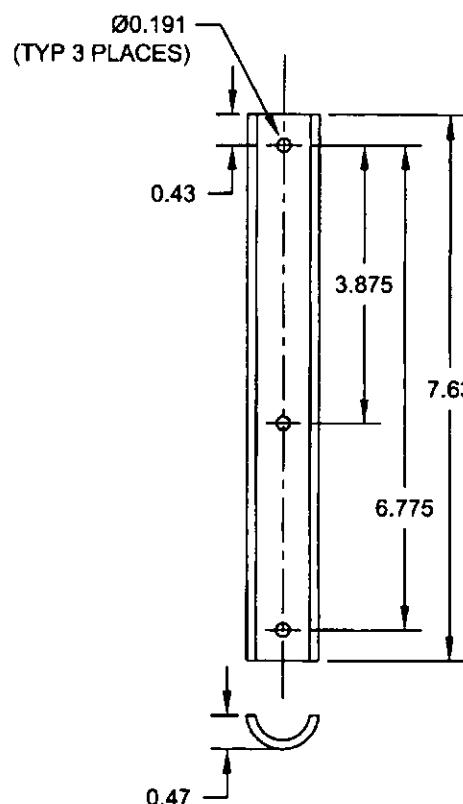
CHANGE:

DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



WAS:



D3016-11 SADDLE

D3016-11 SADDLE

